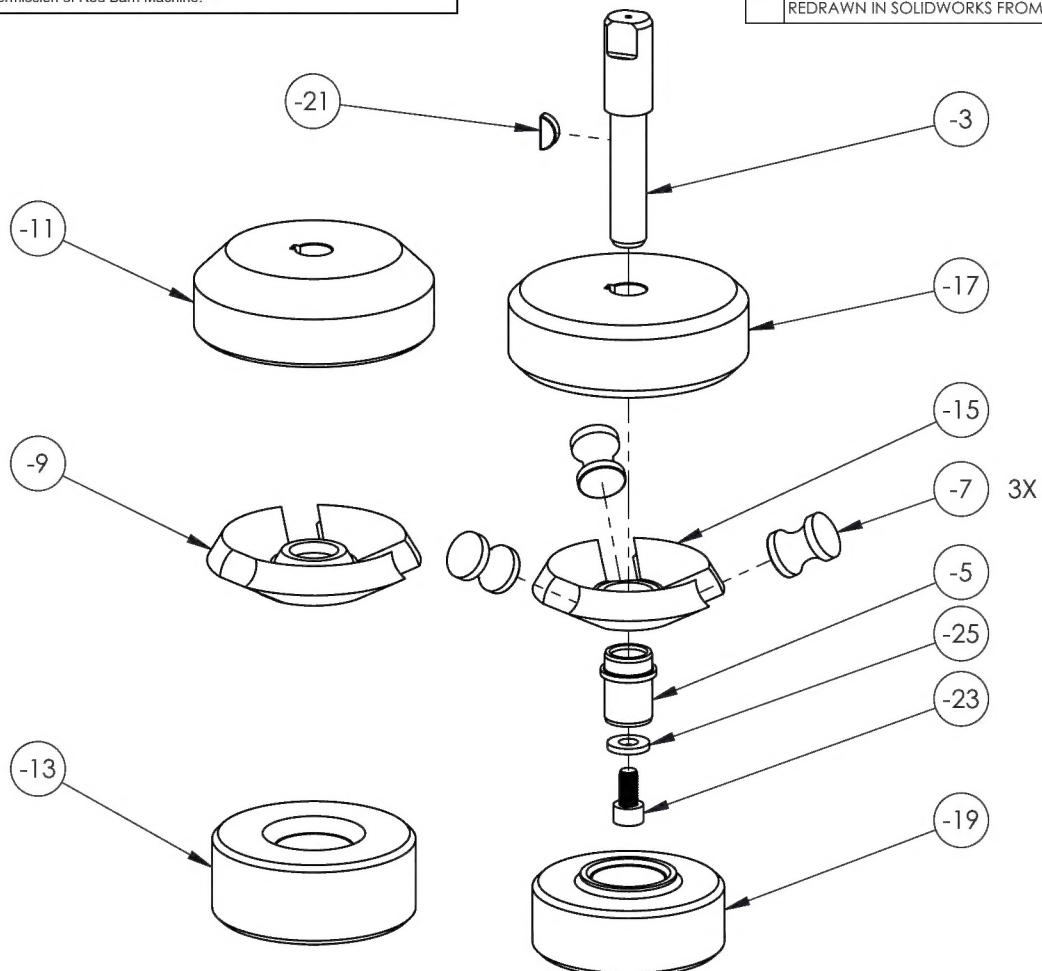


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
	REDRAWN IN SOLIDWORKS FROM TATTERED ORIGINAL DWG.	8/30/2013	CFS	



NOTE:

1. USED ON MODEL: BELL 205A1, 212, 214B, 222, 222B, 222U, 230, 407, 412, & 430.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	ARBOR	01	Ø5/8 X 2-3/4	2
			-5	1	BUSHING	ALUM. BRONZE	Ø5/8 X 1	3
			-7	3	ROLLER	01	Ø5/8 X 3/4	4
			-9	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	5
			-11	1	HOUSING	01	Ø2-5/8 X 1-1/4	6
			-13	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	7
			-15	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	8
			-17	1	HOUSING	01	Ø2-5/8 X 1	9
			-19	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	10
		B/O	-21	1	WOODRUFF KEY	STEEL	#213 WOODRUFF KEY MCMASTER-CARR #98525A075	1
		B/O	-23	1	SOCKET HEAD CAP SCREW	S.S.	#10-32 X 3/8 MCMASTER-CARR #92200A340	1
		B/O	-25	1	FLAT WASHER	STEEL	Ø.438 X .063 AIRCRAFT SPRUCE #AN960-10	1

RED BARN MACHINE

TITLE: STAKING TOOL, TAIL ROTOR YOKE  
FLAP & PITCH CHG BRGS

DWG NO.: RB T101577-1 REV

MATTL DRAWN BY: SMITH APPROVED *D Weil*

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

.XXX ± .010 FRACTIONS ± 1/32

.XX ± .03 ANGLES ± .5°

X ± .1

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R

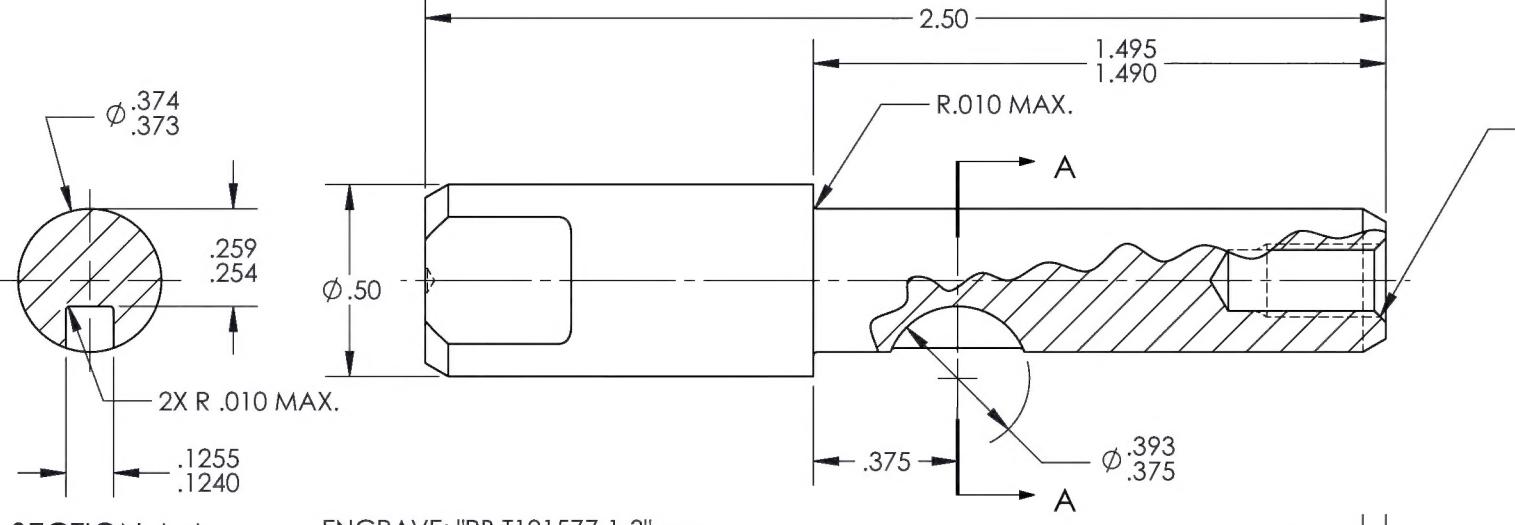
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SEE NOTE

SCALE 1:2 DATE 8/26/2013 SHEET 1 OF 10

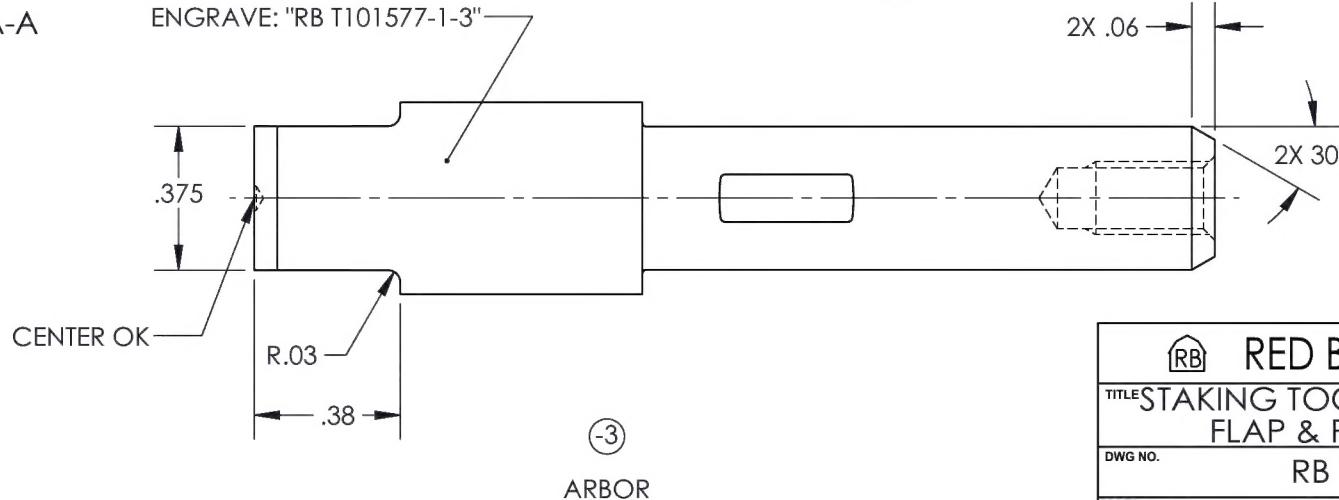
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

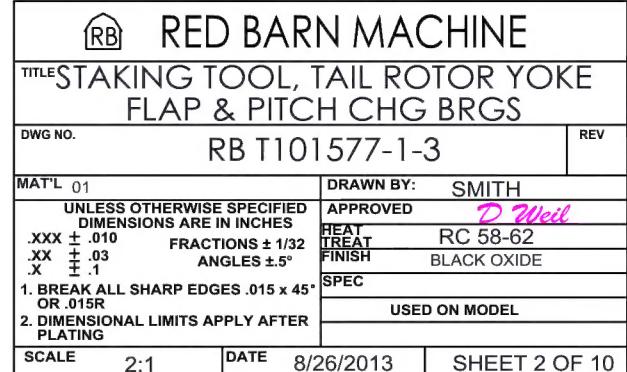


## SECTION A-A

ENGRAVE: "RB T101577-1-3"

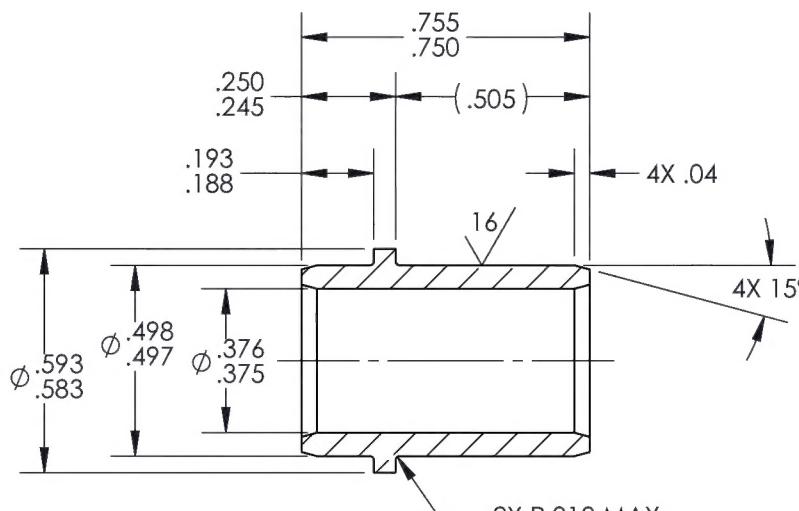
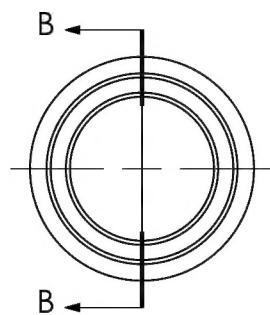


ARBOR



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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



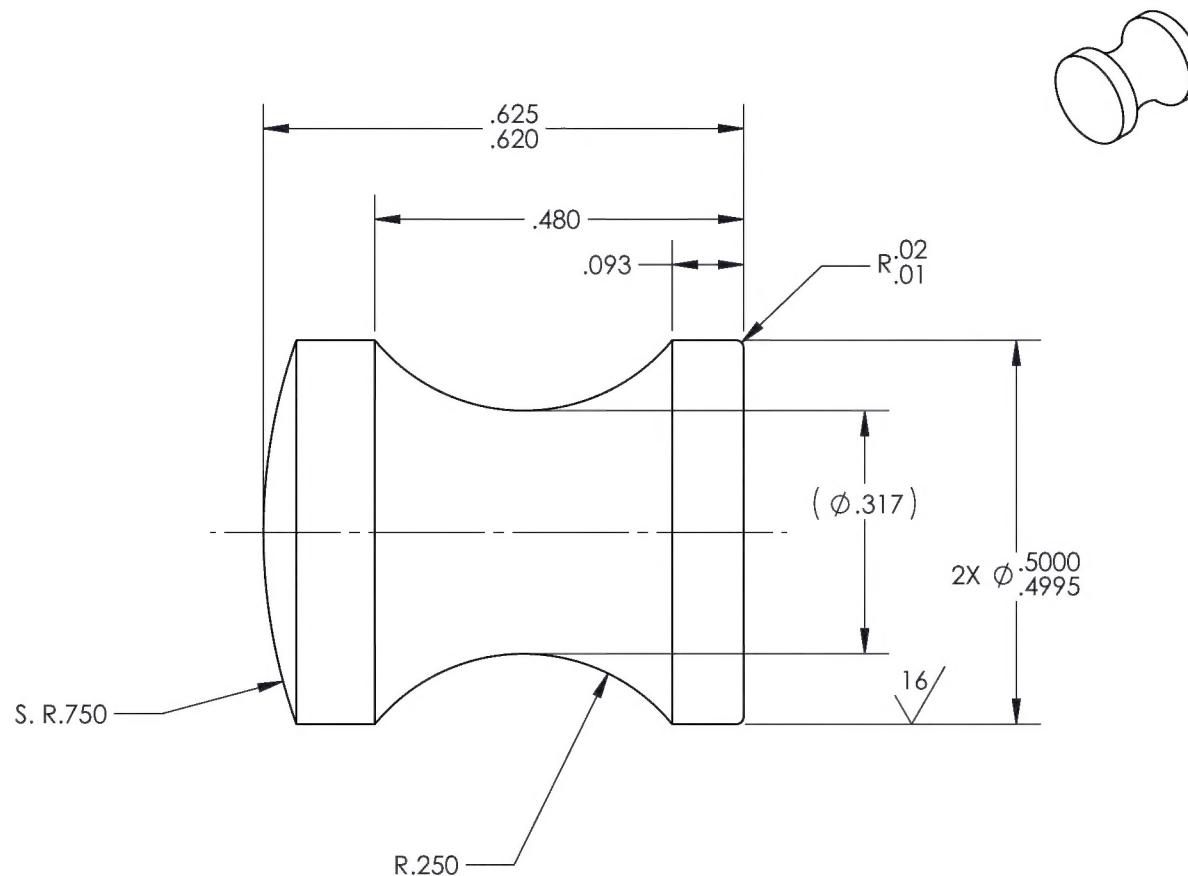
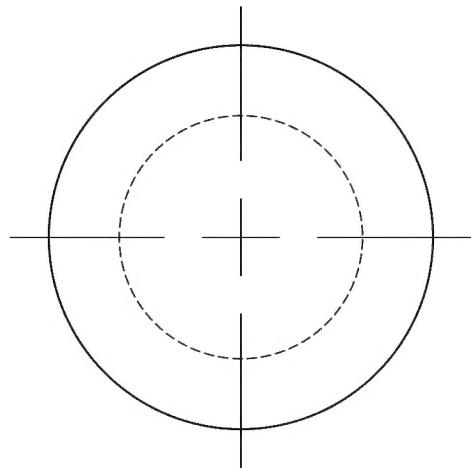
(-5)

BUSHING

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-5
MATL ALUM. BRONZE	DRAWN BY: SMITH APPROVED <i>D Weil</i>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± .5° .X ± .1	
HEAT TREAT FINISH	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC	USED ON MODEL
SCALE 2:1	DATE 8/26/2013
SHEET 3 OF 10	

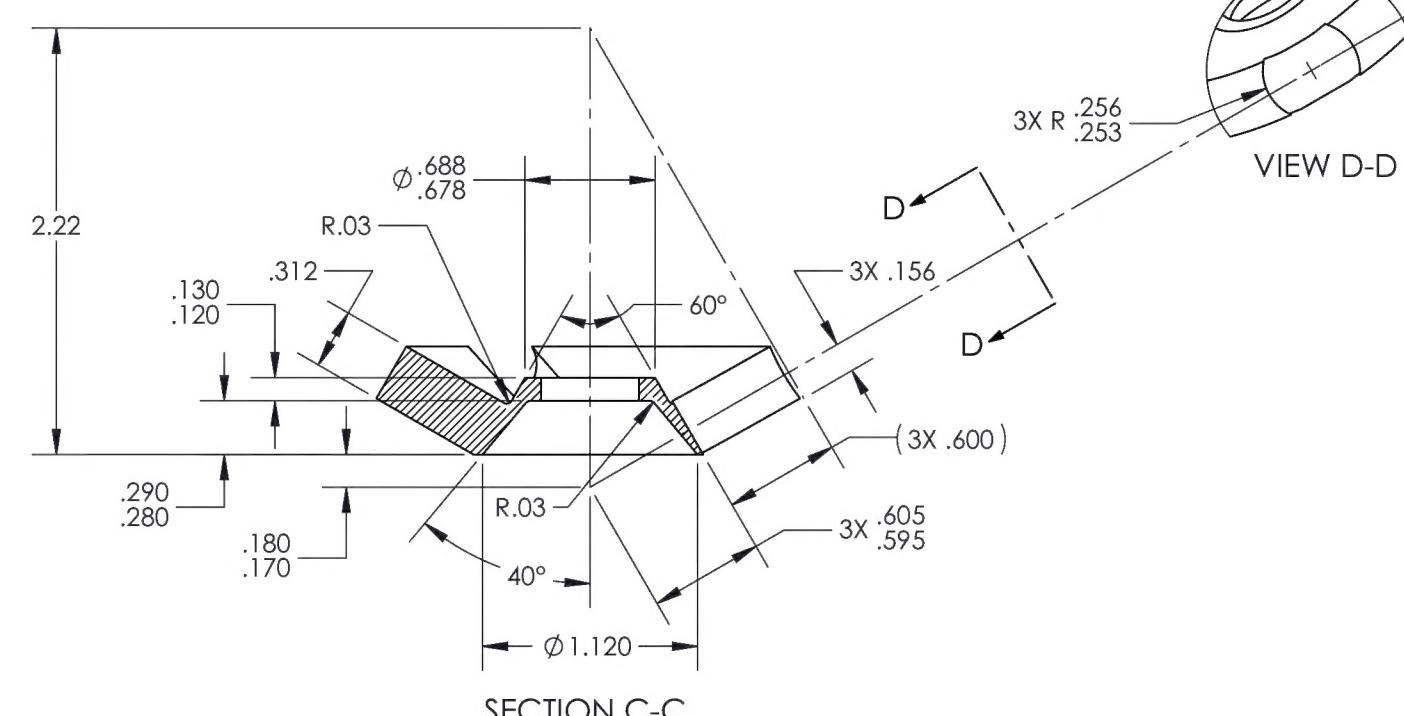
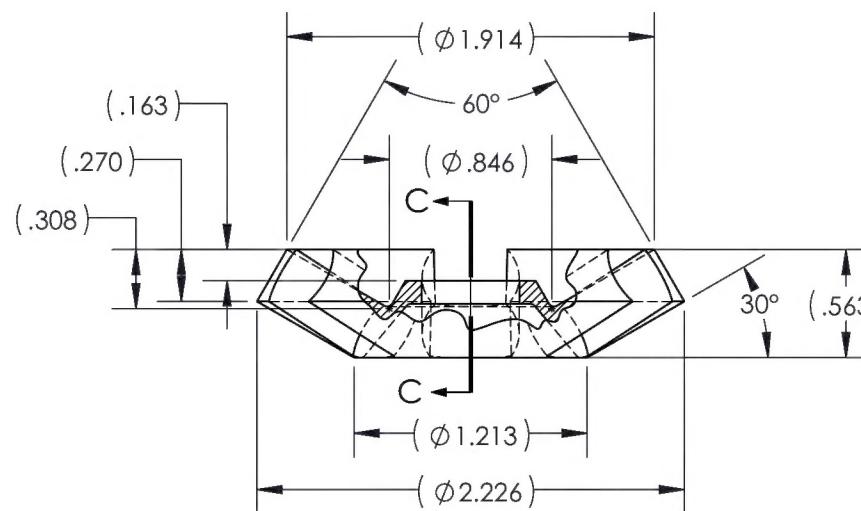
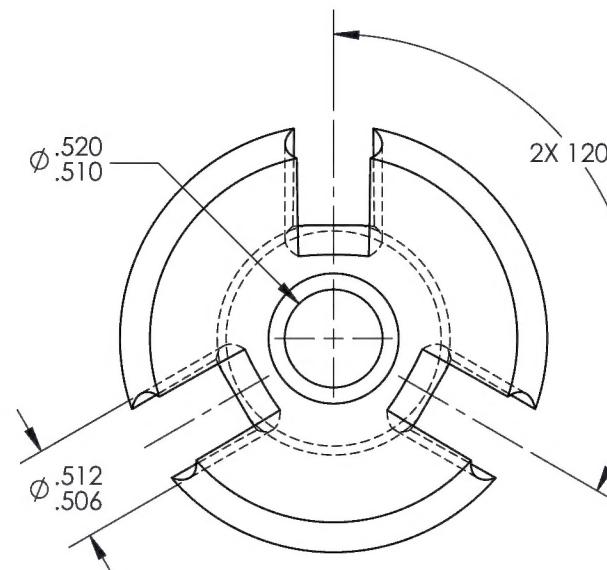
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

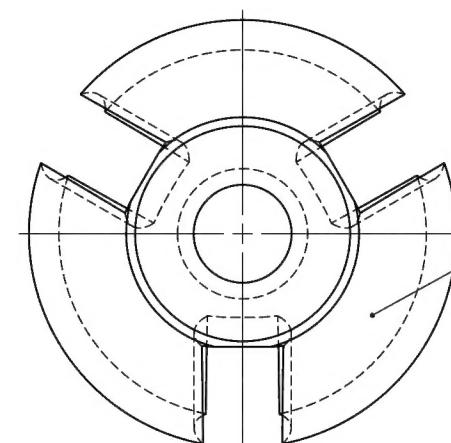


(-7)  
ROLLER

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-7
MATL	01
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: SMITH
.XXX ± .010	APPROVED <i>D. Weil</i>
XX ± .03	HEAT TREAT RC 58-62
X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 2:1	DATE 8/26/2013
	SHEET 4 OF 10



SECTION C-C

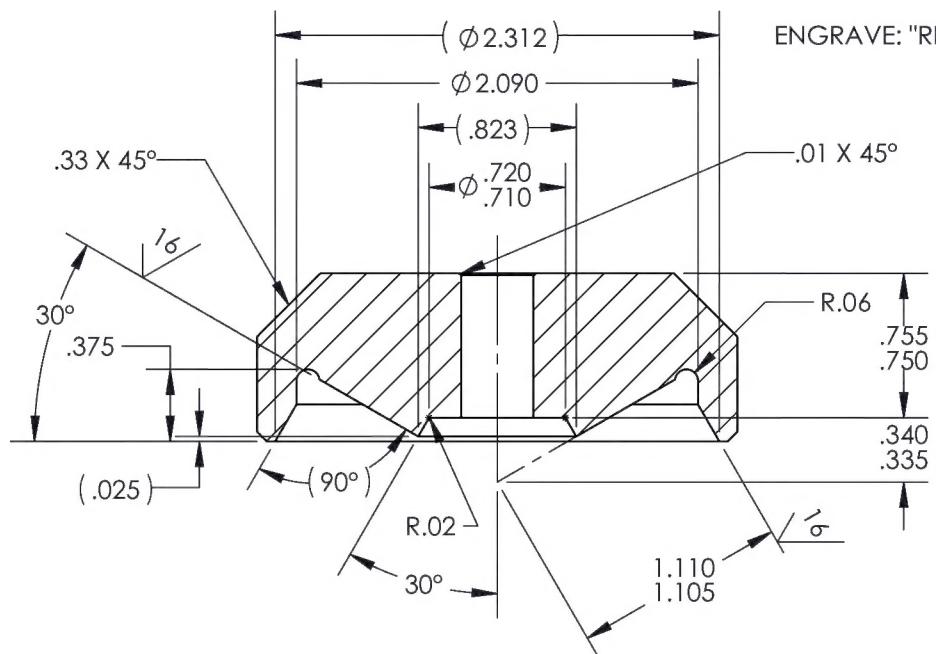


(-9)  
RETAINER

<b>RED BARN MACHINE</b>	
<b>TITLE</b> STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-9	
MAT'L ALUM. BRONZE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED	APPROVED <i>D. Weil</i>
DIMENSIONS ARE IN INCHES	REAR TREAT
.XXX ± .010	FRACTIONS ± 1/32
.XX ± .03	ANGLES ± .5°
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 5 OF 10	

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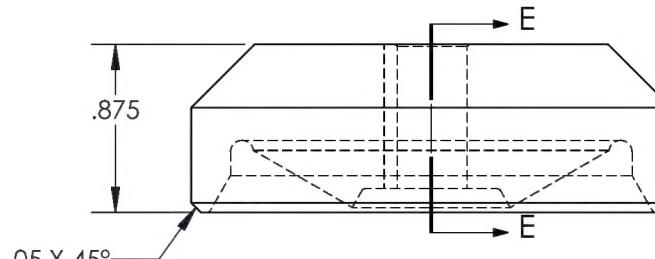
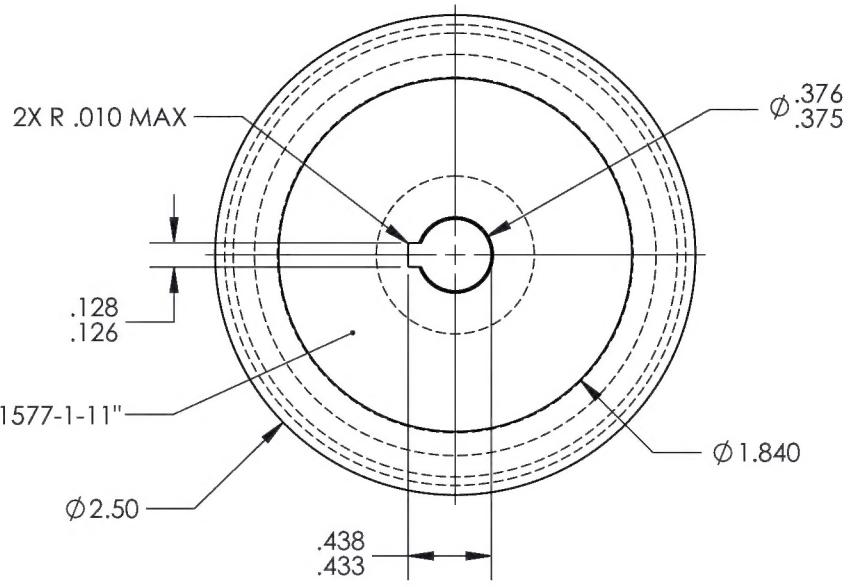
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



SECTION E-E

-11

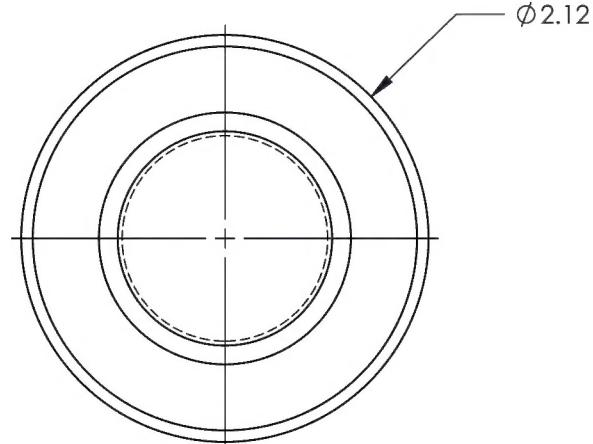
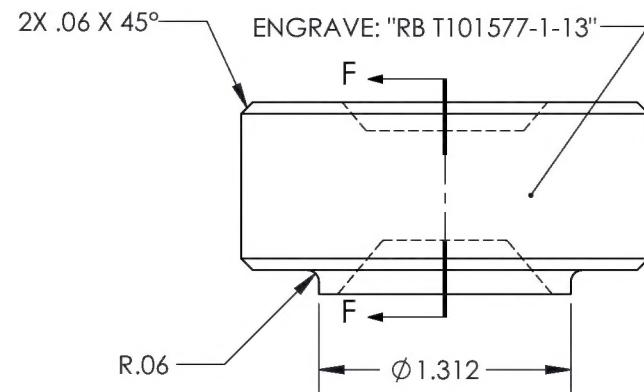
HOUSING



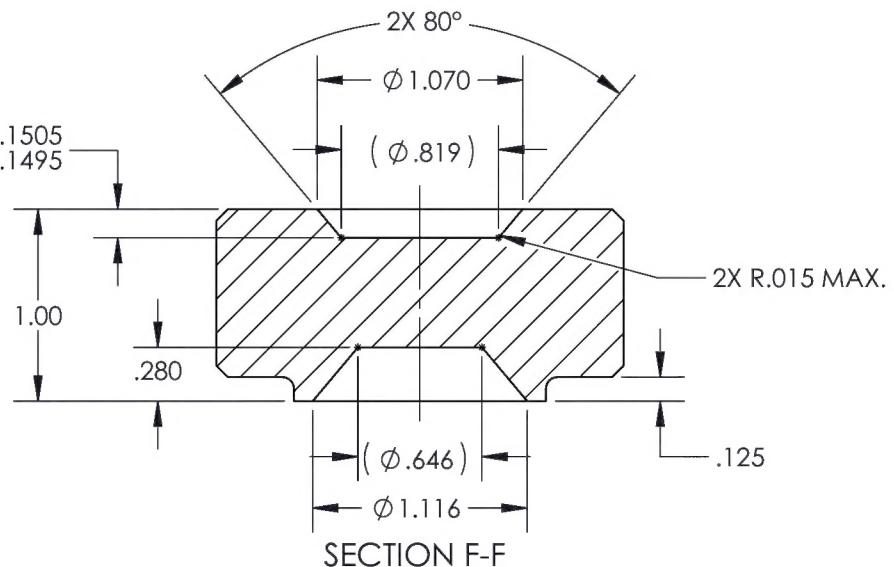
RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-11
MATL	01
DRAWN BY: SMITH	
APPROVED <i>D. Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX $\pm .010$ FRACTIONS $\pm 1/32$	
XX $\pm .03$ ANGLES $\pm .5^\circ$	
X $\pm .1$	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	1:1
DATE	8/26/2013
SHEET 6 OF 10	

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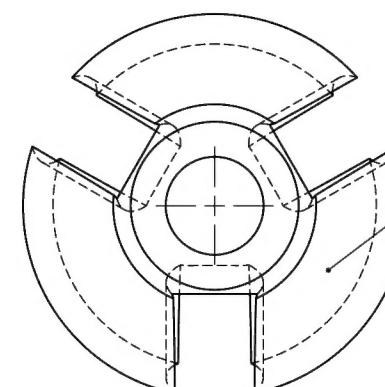
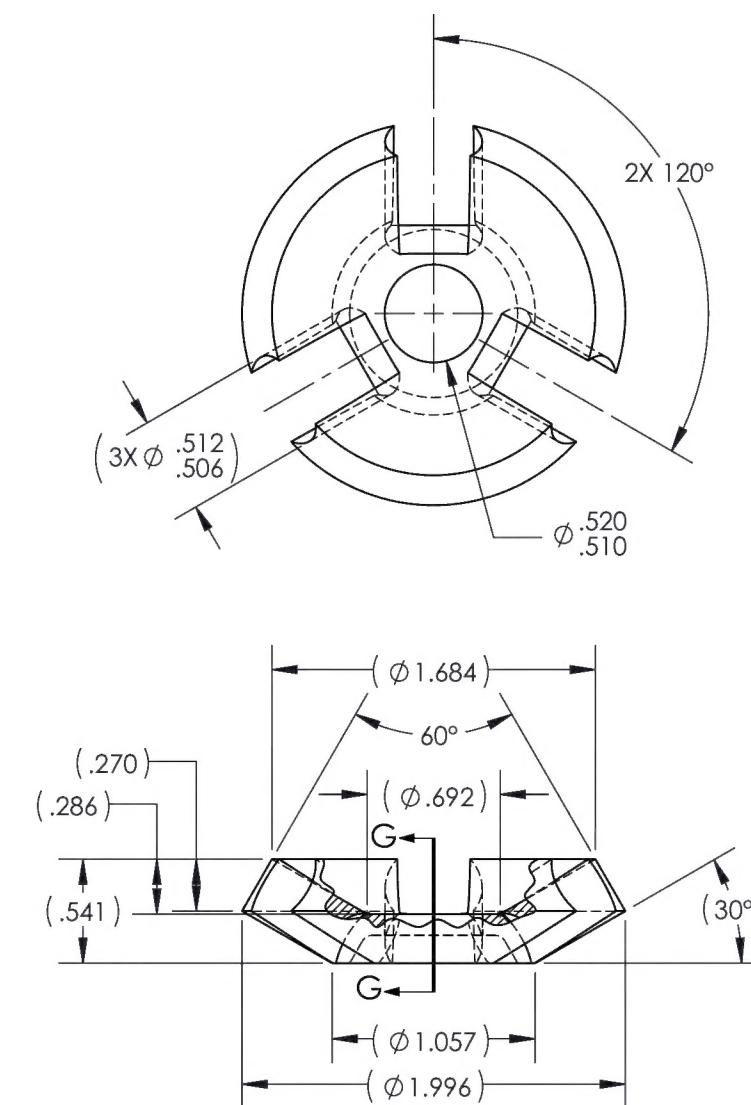
REV		DESCRIPTION		DATE	INITIAL	APPROVED
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(-13)  
BACK STOP



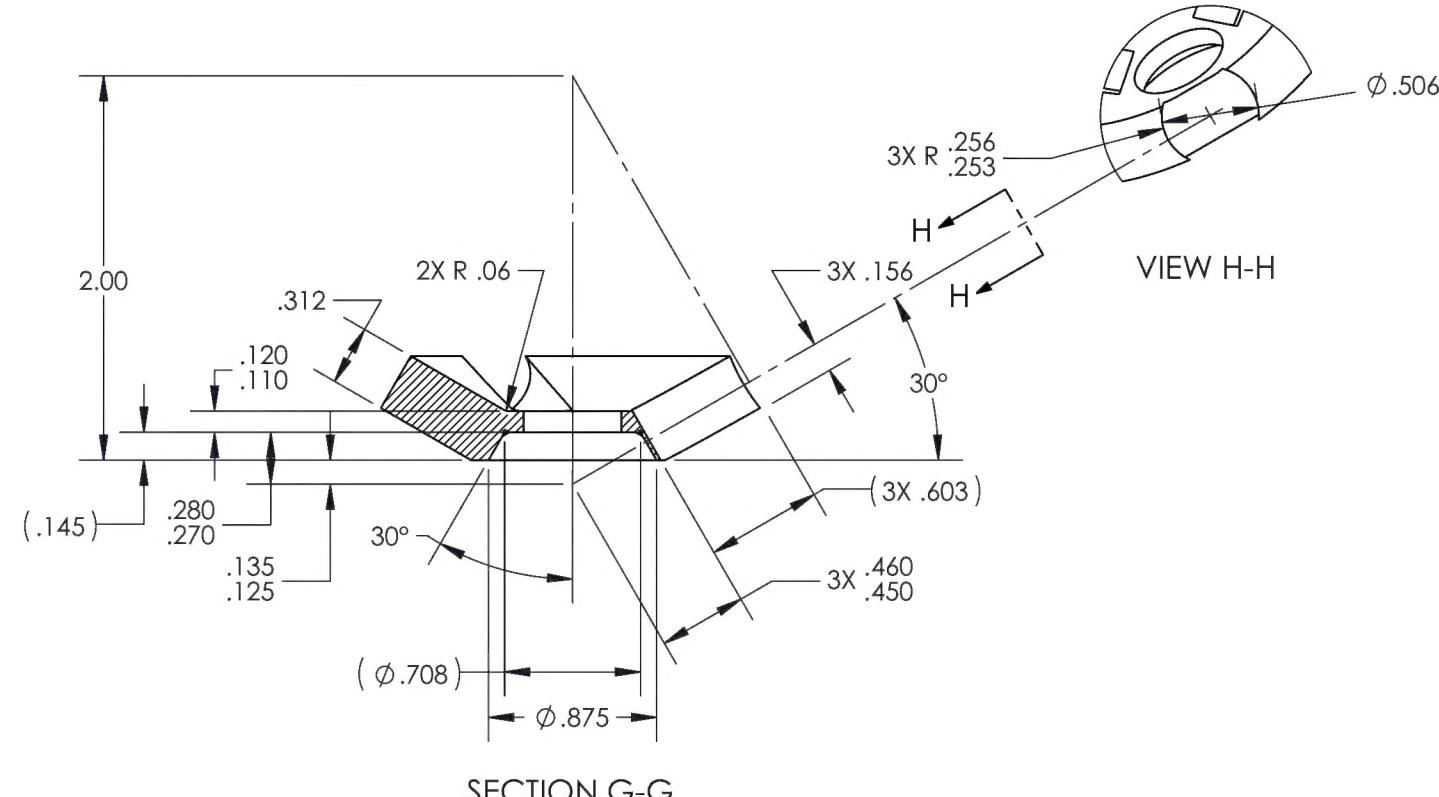
	<b>RED BARN MACHINE</b>	
TITLE	STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	REV
DWG NO.	RB T101577-1-13	
MATL	4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>
.XXX ± .010	FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03	ANGLES ± .5°	FINISH BLACK OXIDE
X ± .1		SPEC
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R		USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE	1:1	DATE 8/26/2013
		SHEET 7 OF 10



ENGRAVE: "RB T101577-1-15"

(-15)

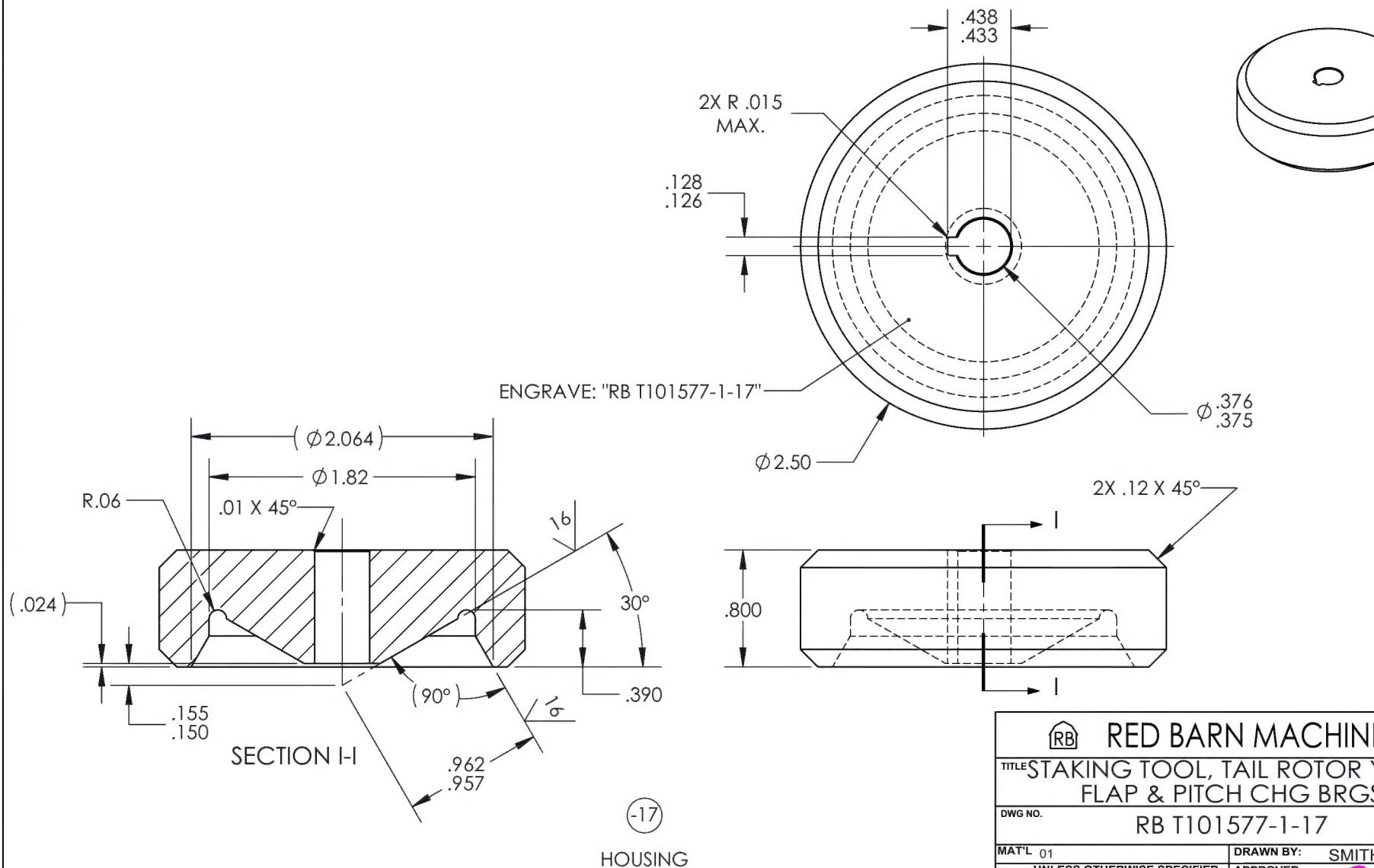
RETAINER



<b>RB RED BARN MACHINE</b>	
<b>TITLE</b> STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-15
DRAWN BY:	SMITH
MAT'L	ALUM. BRONZE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/32
.XX ± .03	ANGLES ± .5°
X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED	D Weil
REAR TREAT	
FINISH	
SPEC	
USED ON MODEL	
SCALE	1:1
DATE	8/26/2013
SHEET 8 OF 10	

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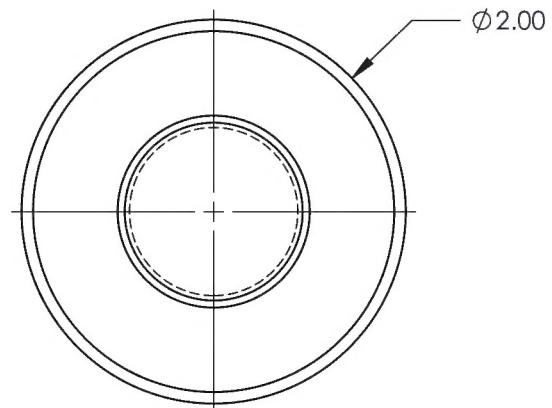
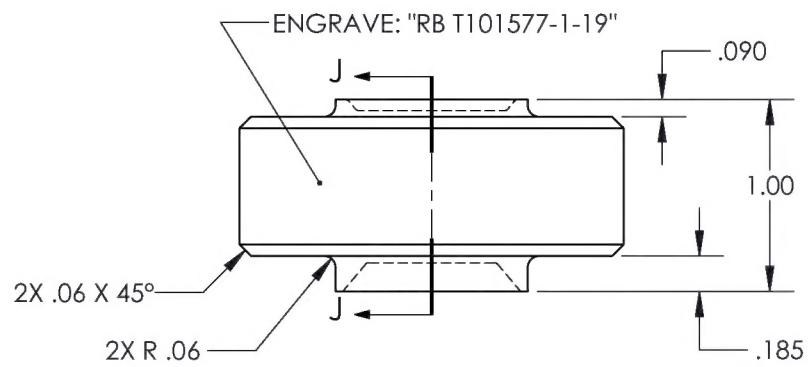
REV		DESCRIPTION		DATE	INITIAL	APPROVED
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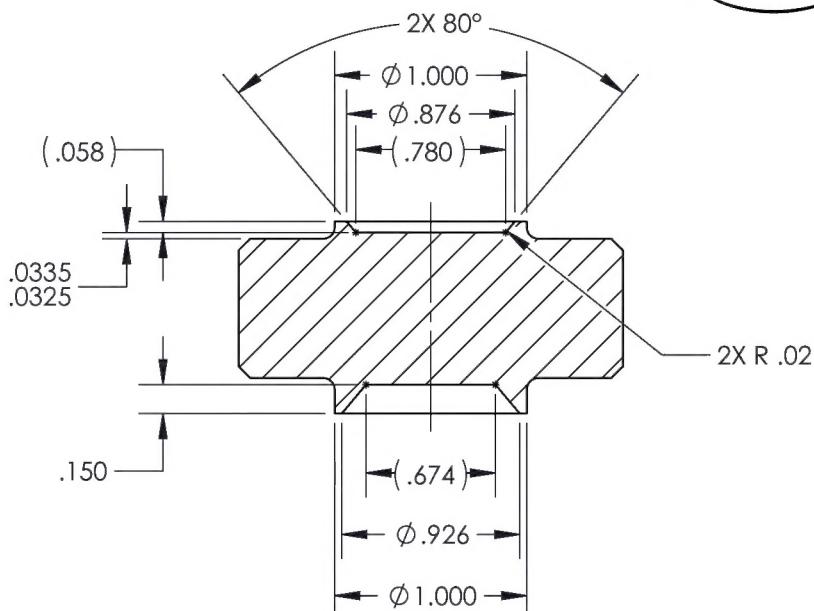
RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-17
MATL	01
DRAWN BY: SMITH	
APPROVED <i>D. Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/32	
XX ± .03 ANGLES ± .5°	
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	1:1
DATE	8/26/2013
SHEET 9 OF 10	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



(-19)  
BACK STOP



	RED BARN MACHINE			
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS				
DWG NO.	RB T101577-1-19			
MATL	4140 Q&T	DRAWN BY: SMITH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
.XXX ± .010      FRACTIONS ± 1/32				
XX ± .03      ANGLES ± .5°				
X ± .1				
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R				
2. DIMENSIONAL LIMITS APPLY AFTER PLATING				
HEAT TREAT FINISH	BLACK OXIDE			
SPEC	USED ON MODEL			
SCALE	1:1	DATE	8/26/2013	SHEET 10 OF 10